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INK-JET HEAD,
FILTER ASSEMBLY USED FOR MANUFACUTURING THE INK-JET HEAD,
AND
METHOD FOR MANUFACTURING THE INK-JET HEAD
5 USING THE FILTER ASSEMBLY

BACKGROUND OF THE INVENTION

[0001]

1. Field of the Invention

10 The present invention relates to an ink-jet head for
ejecting ink onto a record medium to print, a filter
assembly used for the ink-jet head, and a method for
manufacturing the ink-jet head using the filter assembly.

[0002]

15 2. Description of Related Art

In an ink-jet head, ink in an ink tank is lead to a
supply passage, a common ink chamber, a pressure chamber,
and then to a nozzle for ejecting the ink. Such a ink
passage is formed by laminating a plurality of plates each
20 formed with grooves or holes.

[0003]

An ink-jet head, in terms of printing quality, needs
to include a filter for removing foreign matters mixed in
ink. Thus, ~~there are known such techniques that a filter~~
25 is formed in a plate serving as a boundary between a supply

passage and a common ink chamber, among the plurality of plates constituting the above-mentioned ink passage (See Japanese Patent Laid-Open No. 6-255101), and that a filter is formed in a communicating region of a common ink chamber and a pressure chamber (See Japanese Patent Laid-Open No. 2-198851).

[0004]

However, in case that a filter is formed in a plate serving as a boundary between a supply passage and a common ink chamber, the filter needs to be formed corresponding to each common ink chamber, and in case that a filter is formed in a communicating region of a common ink chamber and a pressure chamber, the filter needs to be formed corresponding to each pressure chamber. As a result, each filter becomes relatively small in size and relatively large in number. In these cases, a dimensional error of the filter is often caused. This dimensional error causes a variation of passage resistance in the individual ink passage each corresponding to an individual nozzle, thereby leading to deterioration of printing quality.

SUMMARY OF THE INVENTION

[0005]

An object of the present invention is to provide an ink-jet head capable of realizing an improved printing

quality by restraining a variation of passage resistance in the individual ink passage, a filter assembly used for the ink-jet head, and method for manufacturing the ink-jet head using the assembly.

5 [0006]

According to a first aspect of the present invention, an ink-jet head comprises a passage unit including a plurality of nozzles for ejecting ink, a plurality of pressure chambers each connected to each of the nozzles, a
10 common ink chamber for supplying ink to the pressure chambers, and inlet ports for introducing ink into the common ink chamber; and a branching passage unit including an ink introduction port into which ink is introduced, ink outlet ports formed to correspond to the inlet ports and
15 leading out ink to the inlet ports, an ink branching passage for branching ink from the ink introduction port to the ink outlet ports, and an ink filter formed in the ink branching passage.

[0007]

20 With this construction in which the filter is formed in the ink branching passage in the branching passage unit, the filter can be made larger in size and smaller in number in comparison with a case where a filter is formed in the passage unit such as between the inlet port and the common
25 ink chamber, between the common ink chamber and the

pressure chamber, and the like. Thus, the filters can be integrated. Accordingly, dimensional errors of the filters are not easily caused, and therefore a variation of passage resistance in the individual ink passage is restrained, to
5 realize an improved printing quality.

[0008]

According to a second aspect of the present invention, a filter assembly used for an ink-jet head, the ink-jet head comprising a passage unit including a plurality of
10 nozzles for ejecting ink, a plurality of pressure chambers each connected to each of the nozzles, a common ink chamber for supplying ink to the pressure chambers, and inlet ports for introducing ink into the common ink chamber; and a plurality of filter supporting members arranged on a
15 surface of the passage unit so that each filter supporting member covers the inlet ports, the filter assembly comprises the plurality of filter supporting members disposed to neighbor each other; interconnecting portions for connecting the neighboring filter supporting members
20 with each other, bending strength on a boundary between the interconnecting portion and the filter supporting member being smaller than bending strength of the filter supporting member; and a filter formed in each of the plurality of filter supporting members.

25 [0009]

According to a third aspect of the present invention, a method for manufacturing an ink-jet head, comprises steps of: forming a passage unit including a plurality of nozzles for ejecting ink, a plurality of pressure chambers each
5 connected to each of the nozzles, a common ink chamber for supplying ink to the pressure chambers, and inlet ports for introducing ink into the common ink chamber; manufacturing a filter assembly comprising a plurality of filter supporting members disposed to neighbor each other,
10 interconnecting portions for connecting the neighboring filter supporting members with each other, and a filter formed in each of the plurality of filter supporting members, bending strength on a boundary between the interconnecting portion and the filter supporting member
15 being smaller than bending strength of the filter supporting member; separating the plurality of filter supporting members from each other by bending the interconnecting portions on the boundaries between the interconnecting portions and the filter supporting members;
20 and arranging the plurality of filter supporting members on a surface of the passage unit such that the filter may face each of the inlet ports.

[0010]

With the above second and third aspects, the ink-jet
25 head according to the first aspect can relatively easily be

realized by separating the plurality of filter supporting members included in the filter assembly from each other, and then disposing each of the filter supporting member on the passage unit so that the filter may face the inlet port
5 formed on the surface of the passage unit. Therefore, the same advantage as the above first aspect, i.e., restraint of variation of passage resistance in the individual ink passage in the ink-jet head and improvement of printing quality, can be obtained.

10

BRIEF DESCRIPTION OF THE DRAWINGS

Other and further objects, features and advantages of the invention will appear more fully from the following description taken in connection with the accompanying
15 drawings in which:

FIG. 1 illustrates a general construction of an example of a printer including ink-jet heads according to a first embodiment of the present invention;

FIG. 2 is a bottom view of the ink-jet heads arranged
20 in parallel and illustrated in FIG. 1;

FIG. 3 is a partial sectional view of the ink-jet head illustrated in FIG. 1;

FIG. 4 is an exploded perspective view of a branching passage unit illustrated in FIG. 3;

25 FIG. 5A is a partial perspective view illustrating an

example of methods for introducing ink from an ink supply source into an ink introduction port;

FIG. 5B is a partial sectional view of a cylindrical member and the branching passage unit illustrated in FIG.

5 5A;

FIG. 6 is an enlarged sectional view of an ink passage in a passage unit illustrated in FIG. 3;

FIG. 7 is a partial sectional view, corresponding to FIG. 3, of an ink-jet head according to a second embodiment
10 of the present invention;

FIG. 8 is an exploded perspective view, corresponding to FIG. 5, of a branching passage unit in the ink-jet head illustrated in FIG. 7;

FIG. 9 is a partial sectional view, corresponding to
15 FIG. 3, of an ink-jet head according to a third embodiment of the present invention;

FIG. 10 is an exploded perspective view, corresponding to FIG. 5, of a part of a branching passage unit in the ink-jet head illustrated in FIG. 9;

20 FIG. 11 is a perspective view of a filter assembly used for the ink-jet head illustrated in FIG. 9; and

FIG. 12 is a perspective view illustrating a state where filter supporting members included in the filter assembly in FIG. 11 have been separated from each other and
25 are now to be disposed on a surface of the passage unit.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0011]

FIG. 1 illustrates a general construction of an
5 example of a printer including ink-jet heads according to a
first embodiment of the present invention. The ink-jet
printer 1 according to the present embodiment is a color
ink-jet printer having four ink-jet heads 2. Within the
ink-jet printer 1, a paper feed unit 11 and a paper
10 discharge unit 12 are provided in left and right portions
of FIG. 1, respectively. A paper conveyance path is formed
extending from the paper feed unit 11 to the paper
discharge unit 12 within the ink-jet printer 1.

[0012]

15 A pair of paper feed rollers 5a and 5b are disposed
immediately downstream of the paper feed unit 11 for
putting forward paper as a medium from left to right in FIG.
1. In a middle of the paper conveyance path, two belt
rollers 6 and 7 and a looped conveyor belt 8 are provided.
20 The conveyor belt 8 is wrapped around each of the belt
rollers 6 and 7 as to be stretched between them.

[0013]

The conveyor belt 8 has a two-layered structure made
up of a polyester base body impregnated with urethane and a
25 silicone rubber. The silicone rubber is disposed in an

outer portion of the conveyor belt 8 to form a conveyor face. Paper fed through the pair of paper feed rollers 5a and 5b is kept on the conveyor face of the conveyor belt 8 by holding power. In this state, the paper is conveyed downstream, i.e., rightward in FIG. 1, by driving one belt roller 6 to rotate clockwise in FIG. 1 as indicated by an arrow 90.

[0014]

Pressing members 9a and 9b are respectively provided at positions for feeding paper onto the conveyor belt 8 and for discharging the paper from the conveyor belt 8, respectively. Either of the pressing members 9a and 9b is for pressing the paper onto the conveyor face of the conveyor belt 8 so as to prevent the paper from separating from the conveyor face. Thus, the paper is surely kept on the conveyor face.

[0015]

A peeling device 10 is provided in the paper conveyance path immediately downstream of the conveyor belt 8, i.e., on the right in FIG. 1. The peeling device 10 peels off the paper, which has been kept on the conveyor face of the conveyor belt 8 by holding power, from the conveyor face, so that the paper can be transferred toward the rightward paper discharge unit 12.

[0016]

Each of the four ink-jet heads 2 has, at its lower end, a head main body 2a. Each head main body 2a has a rectangular section. The head main bodies 2a are arranged close to each other with the longitudinal axis of each head main body 2a being perpendicular to the paper conveyance direction, i.e., perpendicular to FIG. 1. That is, this printer 1 is a line type. The bottom of each of the four head main bodies 2a faces the paper conveyance path. In the bottom of each head main body 2a, a large number of nozzles are provided each having a small-diameter ink ejection port 13 (see FIG. 2). The four head main bodies 2a eject ink of magenta, yellow, cyan, and black, respectively.

[0017]

The head main bodies 2a are disposed such that a narrow clearance is formed between the lower face of each head main body 2a and the conveyor face of the conveyor belt 8. The paper conveyance path is formed within the clearance. In this construction, while paper, which is being conveyed by the conveyor belt 8, passes immediately below the four head main bodies 2a in order, the respective color inks are ejected through the corresponding nozzles toward the upper face, i.e., the print face of the paper, to form a desired color image on the paper.

[0018]

FIG. 3 illustrates a partial sectional view of the ink-jet head 2. The ink-jet head 2 is attached through a holder 15 to an adequate member 14 provided within the printer 1. The holder 15 has an inversed-T shape in a side view, made up of a vertical portion 15a and a horizontal portion 15b. The vertical portion 15a is fixed to the member 14 with a screw 16. The head main body 2a is fixed to the lower face of the horizontal portion 15b with a spacer 3 positioned therebetween. The head main body 2a includes, from the lower, a passage unit 20, an actuator unit (actuator) 19 fixed to a surface of the passage unit 20, and a branching passage unit 40 fixed to the surface of the passage unit 20 with the actuator unit sandwiched therebetween.

15 [0019]

A construction of the branching passage unit 40 will here be described with reference to FIGS. 3 and 4.

[0020]

The branching passage unit 40 is constituted by laminating a first plate 41, a second plate 42, and a third plate 43 with each other. Among these three plates 41 to 43, the first plate 41 and the second plate 42 are made of metal such as stainless steel, and the third plate 43 is formed by a metal plate 43a such as a plate of stainless steel and a resin plate 43c such as a plate of polyimide

being laminated with each other. The third plate 43 is arranged so that the metal plate 43a may face the passage unit 20.

[0021]

5 Referring to FIG. 4, at a widthwise center on one side of the first plate 41 in a longitudinal direction thereof, formed by etching, etc., is an ink introduction port 41a penetrating through the plate in its thickness direction. Ink is introduced from an ink supply source 200
10 such as an ink tank into the ink introduction port 41a, for example as illustrated in FIG. 5A, through a cylindrical member 201 and a tube 200a connected to the cylindrical member 201.

[0022]

15 As illustrated in FIG. 5B, the cylindrical member 201 has a cylindrical base 201b and a reduced diameter portion 201c on an opposite of the base 201b. The reduced diameter portion 201c has a reduced diameter and a tip 201a formed in a tapered shape. The base 201b is press-fitted into the
20 ink introduction port 41a, and an end of the tube 200a extending from the ink supply source 200 is externally fitted to an outer peripheral surface of the reduced diameter portion 201c. When a portion of the cylindrical member 201 to which the tube 200a is attached (the reduced
25 diameter portion 201c) is thus formed in the tapered shape,

the tube 200 can easily be attached. Moreover, in case that the tube 200a is omitted and the ink supply source 200 is directly attached to the cylindrical member 201, an attachment can easily be performed likewise.

5 [0023]

The cylindrical member 201 is preferably made of the same material as that of the first plate 41. In this case, since the cylindrical member 201 and the first plate 41 have the same linear expansion coefficients, they expand
10 and contract in the same way due to changes in temperature, humidity, and the like. Accordingly, tight-coupling between the cylindrical member 201 and the first plate 41 can be kept well. Thus, air inflow through a gap between the base 201b of the cylindrical member 201 and the ink
15 introduction port 41a can be prevented.

[0024]

More preferably, the cylindrical member 201 and the first plate 41 are both made of stainless steel. Since stainless steel has an excellent ink resistance, various
20 types of ink may be used. Stainless steel is also excellent in air barrier properties. Therefore, it can be prevented that air passes the cylindrical member 201 and the ink introduction port 41a to generate bubbles in an ink branching passage in the branching passage unit 40.

25 [0025]

In the second plate 42, as illustrated in FIGS. 3 and 4, a hole to constitute an ink reservoir 42a for storing ink is formed, by press working, etc., along a longitudinal direction of the second plate 42 (direction perpendicular to FIG. 3). Further, a plurality of notches 42c having nearly semicylindrical shape are serially formed at sidewalls of the hole to constitute the ink reservoir 42a, as illustrated in FIG. 4.

[0026]

10 At portions of the metal plate 43a in the third plate 43 corresponding to below-described inlet ports 20a in the passage unit 20, formed are ink outlet ports 43b having the same shape as that of the inlet port 20a and penetrating through the plate in its thickness direction (see FIG. 3).
15 The portions where the ink outlet ports 43b are formed also correspond to the notches 42c in the second plate 42 illustrated in FIG. 4.

[0027]

At portions of the resin plate 43c in the third plate 20 43 corresponding to the below-described inlet ports 20a in the passage unit 20, i.e., corresponding to the above-mentioned ink outlet ports 43b, formed are ink filters 43f having the same shape as that of the inlet port 20a and the ink outlet port 43b.

25 [0028]

The ink outlet ports 43b are formed by etching the metal plate 43a, and subsequently, the filters 43f are formed by making, with excimer laser machining, a large number of small-diameter pores (16 to 24 micrometers) to neighbor each other concentratedly at the portions of the resin plate 43c corresponding to the ink outlet ports 43b.

[0029]

Further, a part of the metal plate 43a in the third plate 43 is cut off by etching, etc., and remaining are only areas including the ink outlet ports 43b, which is indicated by dotted lines in FIG. 4. Thus, a concavity 43g is formed in the third plate 43 facing the passage unit 20. As illustrated in FIG. 3, the concavity 43g forms a space 44 in which the actuator unit 19 (illustrated on the surface of the passage unit 20 with alternate long and two short dashes lines in FIG. 4) is to be arranged.

Protrusions 43h protruding toward the passage unit 20 is formed at areas of the metal plate 43a corresponding to outsides of long sides of the actuator units 19 (areas outside of alternate long and short dash lines in FIG. 4) (see FIG. 3). The protrusion 43h has such a height that a below-described flexible printed circuit (FPC) 4 may be drawn out from the space 44 to the outside. The protrusion 43h closes the space 44.

[0030]

The number of processing steps can be reduced by performing two etchings in the metal plate 43a at the same time, i.e., the etching for forming the concavity 43g and the etching for forming the ink outlet ports 43b.

5 [0031]

The above-described first to third plates 41 to 43 are laminated with each other, so that an ink branching passage for branching ink from the ink introduction port 41a to the ink outlet ports 43b is formed within the
10 branching passage unit 40.

[0032]

The passage unit 20 has circular inlet ports 20a (see FIGS. 2 and 3) facing the branching passage unit 40. The passage unit 20 is bonded to the branching passage unit 40
15 so that respective inlet ports 20a may communicate with respective portions corresponding to the notches 42c of the branching passage unit 40. Thus, ink in the ink reservoir 42a can flow into the passage unit 20 through the inlet ports 20a.

20 [0033]

The actuator unit 19 is bonded to the upper face of the passage unit 20, and more specifically, in a region other than the region where the upper face of the passage unit 20 the branching passage unit 40 is bonded. The
25 actuator units 19 is separated from the branching passage

unit 40. That is, although the branching passage unit 40 is in contact with the passage unit 20 in the vicinity of the inlet port 20a, the branching passage unit 40 is spaced from the head main body 2a in the other region. The
5 actuator unit 19 is disposed within the separation region. As illustrated with alternate long and two short dashes lines in FIG. 4, each actuator unit 19 has a substantially trapezoidal shape in plan. Actuator units 19 are arranged in a zigzag manner along the length of the head 2. Each
10 actuator unit 19 is disposed so that its parallel opposite sides, i.e., the upper and lower sides, are along of the length of the passage unit 20. Oblique sides of each neighboring actuator units 19 overlap each other along the width of the passage unit 20. the region of the lower face
15 of the passage unit 20 corresponding to a bonded region of each actuator unit 19 is made into an ink ejection region.

[0034]

The inlet ports 20a in the passage unit 20 as described above are arranged so as to correspond to regions
20 where no actuator unit 19 is disposed. In more detail, as shown in fig. 4, the inlet ports 20a includes ones arranged countercorner at both ends in a longitudinal direction of the passage unit 20 and the other arranged with making pairs near respective short sides of opposing parallel
25 sides of the actuator units 19 in a zigzag manner. Since

the plurality of inlet ports 20a are arranged at a distance therebetween in the longitudinal direction of the passage unit 20, even if the head 2 is elongated, ink in the ink reservoir 42a can stably be supplied to the passage unit 20 with passage resistance restrained.

[0035]

Next, an ink passage in the passage unit 20 will be described in more detail with reference to FIG. 6. FIG. 6 is an enlarged sectional view of an ink passage in a passage unit illustrated in FIG. 3.

[0036]

The passage unit 20, as illustrated in FIG. 6, has a layered structure of nine metallic thin flat plates 21, 22, 23, 24, 25, 26, 27, 28, and 29. A manifold channel (common ink chamber) 30 is formed by the flat plates 25 to 27 in such a manner as to lie across these three plates, which constitute fifth to seventh layers from a top. The manifold channel 30 communicates with the above-described inlet ports 20a through a not-illustrated path. A communication hole 31 is formed in the fourth flat plate 24 disposed immediately on the manifold channel 30. The communication hole 31 connects with an aperture 32 formed in the third flat plate 23.

[0037]

The aperture 32 communicates with one end of a

pressure chamber 34 formed in the first flat plate 21
through a communication hole 33 formed in the second flat
plate 22. The pressure chambers 34, which correspond to
respective nozzles one by one, are for applying pressure to
5 ink by means of a drive of the actuator unit 19 fixed onto
an upper face of the passage unit 20. The other end of the
pressure chamber 34 communicates with a nozzle of tapered
shape formed in the ninth flat plate 29 through a nozzle
communication hole 35 formed in the second to eighth flat
10 plates to penetrate these seven plates. An ink ejection
port 13 is formed at an front end of the nozzle.

[0038]

A planer shape of the pressure chamber 34 is
substantially of elongated diamond or of parallelogram
15 (illustration is omitted).

[0039]

In the head main body 2a having the above
construction, as illustrated in FIG. 5A for example, ink
introduced from the ink supply source 200 is firstly
20 introduced through the ink introduction port 41a into the
ink reservoir 42a, where the ink is reserved for a time.
The ink in the ink reservoir 42a subsequently passes
through the notches 42c, and then through the filters 43f.
At this time, foreign matters mixed in the ink are removed
25 by the filters 43f. The ink, after passing through the

filters 43f, reaches the ink outlet ports 43b (see FIG. 4). The ink is then led from the ink outlet ports 43b into the inlet ports 20a in the passage unit 20, and further into the manifold channel 30. The ink in the manifold channel
5 30 is, as illustrated in FIG. 6, supplied to each pressure chamber 34 through the communication hole 31, the aperture 32, and the communication hole 33. A drive of the actuator unit 19, as described below, applies pressure to the ink in
10 the ink ejection port 13 through the nozzle communication hole 35.

[0040]

The actuator unit 19 is constructed by laminating a plurality of piezoelectric sheets made of a ceramic
15 material such as lead zirconate titanate (PZT). Thin film electrodes made of, e.g., an Ag-Pd-base metallic material are interposed between the piezoelectric sheets, so that active portions are formed at regions facing respective pressure chambers 34. When a potential difference is
20 caused between the electrodes arranged in the piezoelectric sheets in the below-described manner, each active portion deforms into a convex shape toward the pressure chamber 34. As a result, a volume of the pressure chamber 34 is reduced to apply pressure to the ink in the pressure chamber 34.

25 [0041]

As illustrated in FIG. 6, an FPC 4, acting as a power supply member to the actuator unit 19, is bonded to an upper face of the actuator unit 19. As illustrated in FIG. 3, the FPC 4 is drawn out from a side of the ink-jet head main body 2a, bent upward, and electrically connected to a driver integrated circuit (IC) (not illustrated) mounted on a side face of the member 14. Drive pulses generated in the driver IC are supplied, through the FPC 4, to the electrodes in the actuator unit 19, so as to deform the above-described active portions. Such a potential control is performed corresponding to each pressure chamber 34 independently of one another.

[0042]

Moreover, as illustrated in FIG. 3, a silicon-base seal member 36 is disposed at a side of the head main body 2a corresponding to an opening for drawing out the FPC 4. The seal member 36 serves to safeguard the FPC 4 as well as to seal the above-mentioned space 44 in order to prevent ink, etc., from entering the space 44.

[0043]

As described above, in the ink-jet head 2 according to the present embodiment, since the ink filters 43f are formed in the ink branching passage within the branching passage unit 40, the filter can be made larger in size and smaller in number in comparison with a case where the

filters are formed in the passage unit 20. Thus, the filters can be integrated. Accordingly, dimensional errors of the filters 43f are not easily caused, and therefore a variation of passage resistance in the individual ink passage is restrained, to realize an improved printing quality.

[0044]

Also, in case that the filter is formed in the ink passage within the passage unit 20 (e.g., at the communication hole 31 or the throttle part 32), the flat plates 21 to 29 (see FIG. 6) need be positioned with each other with relatively strict accuracy in order to align a position of the filter with each part. In the present embodiment, on the other hand, there is not required so strict accuracy in positioning for surely passing ink through the filters 43f. Moreover, since a filter is not formed in the flat plates 21 to 29, the flat plates 21 to 29 constituting the passage unit 20 can relatively easily be positioned with each other. Therefore, the ink-jet head 2 can easily be manufactured, so as to realize an improved manufacture yield and reduced manufacture cost.

[0045]

The filters 43f are formed in the plate 43, which is one of the plates constituting the branching passage unit 40. Thus, the filters 43f can be formed easily by, e.g.,

etching or excimer laser machining.

[0046]

A use of excimer laser machining for forming the large number of pores constituting the filter 43f can, in comparison with etching, etc., stabilize shapes and sizes of the pores. Passage resistance in the individual ink passage is thereby stabilized.

[0047]

Moreover, since the third plate 43 formed with the filters 43f has a layered structure laminated with the metal plate 43a and the resin, e.g., polyimide, plate 43c, the ink outlet ports 43b can be formed by etching the metal plate 43a, and at the same time, the filters 43f can easily be formed by making a large number of pores, with excimer laser machining, at the portions of the resin plate 43c corresponding to the ink outlet ports 43b. In the above-described method for forming filters, a manufacture cost of the filter 43f can be reduced.

[0048]

In this case, additionally, strength of the filter 43f can be well maintained compared with a case where the filter is formed in a single plate, because the resin plate 43c is backed with the metal plate 43a. Since the third plate 43 thereby advantageously has good strength, laminating of the third plate 43 and the second plate 42

can easily be performed.

[0049]

Further, the filters 43f are disposed between the ink reservoir 42a and the ink outlet port 43b. More specifically, the filters 43f are formed at portions of the third plate 43 having the ink outlet ports 43b, corresponding to respective ink outlet ports 43b, among the plates constituting the branching passage unit 40. Ink once reserved in the ink reservoir 42a flows through the notches 42c into the filters 43f, and then reaches ink outlet ports 43b. In this case, passage resistance does not largely vary before and after the ink passes through the filters 43f, i.e., while the ink flows from the notches 42c into the ink outlet ports 43b. Therefore, the ink can flow smoothly, without generating bubbles in passing the filters 43f.

[0050]

Next, an ink-jet head according to a second embodiment of the present invention will be described with reference to FIGS. 7 and 8. An ink-jet head 102 of the present embodiment differs from that of the first embodiment only in its branching passage unit. The other components, such as a passage unit 20, etc., are identical to those of the first embodiment, and therefore, will not be described by designating them by common reference

numerals.

[0051]

A branching passage unit 50 is constituted by laminating with each other a first plate 51, a second plate 52, and a third plate 53 disposed between the first plate 50 and the second plate 52. Among these three plates 51 to 53, the first plate 51 and the second plate 52 are made of metal such as stainless steel, and the third plate 53 is formed by a metal plate 53a such as a plate of stainless steel and a resin plate 53c such as a plate of polyimide being laminated with each other. The third plate 53 is arranged so that the metal plate 53a may face the second plate 52.

[0052]

Referring to FIG. 8, at a widthwise center on one side of the first plate 51 in a longitudinal direction thereof, formed by etching, etc., is an ink introduction port 51a penetrating through the plate in its thickness direction. Similarly to the first embodiment, ink is introduced from an ink supply source 200 (see FIG. 5A) such as an ink tank into the ink introduction port 51a. Further, as shown in FIG. 8, a slot 51b is formed in the first plate 51 facing the third plate 53. One end of the slot 51b is connected to the ink introduction port 51a, and the other end extends to substantially a middle of the plate in its

longitudinal direction.

[0053]

Three reservoir communication holes 53b neighboring each other along a longitudinal direction of the plate are formed at a substantial center of the metal plate 53a in the third plate 53, i.e., at a portion to be a substantial center of a below-described ink reservoir 52a. Filters 53f having a large number of pores and the same shape as that of the reservoir communication holes 53b are formed at portions of the resin plate 53c in the third plate 53, corresponding to the reservoir communication holes 53b.

[0054]

The reservoir communication holes 53b are formed by etching the metal plate 53a, and subsequently, the filters 53f are formed by making, with excimer laser machining, a large number of small-diameter pores (16 to 24 micrometers) to neighbor each other concentratedly at the portions of the resin plate 53c corresponding to the reservoir communication holes 53b.

[0055]

In the second plate 52 facing the third plate 53, formed by half etching, etc., is a concavity to constitute an ink reservoir 52a having the same planer shape as that of the hole to constitute the ink reservoir 42a in the first embodiment (see FIG. 4). Moreover, notches 52c

having the same planer shape as that of the notches 42c in the first embodiment (see FIG. 4) are serially formed, by half etching, etc., at sidewalls of the concavity to constitute the ink reservoir 52a. Further, at vicinities of the notches 52c corresponding to the inlet ports 20a of the passage unit 20, formed are ink outlet ports 52b having the same shape as that of the inlet ports 20a and penetrating through the plate in its thickness direction.

[0056]

10 A concavity 52g having the same planer shape as that of the concavity 43g in the first embodiment (see FIG. 4) is formed, by half etching, etc., in the second plate 52 facing the passage unit 20. Protrusions 52h similar to the protrusions 43h in the first embodiment is formed at areas of the second plate 52 corresponding to outsides of long sides of actuator units 19 (areas outside of alternate long and short dash lines in FIG. 8) (see FIG. 7).

[0057]

20 The above-described first plate 51, the second plate 52, and the third plate 53 disposed between these two plates are laminated with each other, so that an ink branching passage for branching ink from the ink introduction port 51a to the ink outlet ports 52b is formed within the branching passage unit 50.

25 [0058]

In the head main body 102a having the above construction, as illustrated in FIG. 5A for example, ink introduced from the ink supply source 200 is firstly introduced from the ink introduction port 51a into the slot 51b, and then passes through the filters 53f. At this time, foreign matters mixed in the ink is removed by the filters 53f. The ink having passed through the filters 53f is introduced through the reservoir communication holes 53b into the ink reservoir 52a, where the ink is reserved for a time. The ink in the ink reservoir 52a is subsequently led, through the notches 52c, from the ink outlet ports 52b into the inlet ports 20a in the passage unit 20, and then introduced into a manifold channel 30. The ink flows from the manifold channel 30 to an ink ejection port 13 in the same manner as in the first embodiment. Thus, the description of the ink flow thereafter is omitted.

[0059]

As described above, in the ink-jet head 102 according to the present embodiment, since the ink filter 53f is disposed between the ink introduction port 51a and the ink reservoir 52a, the filter can be made further larger in size and smaller in number, in comparison with a case of the first embodiment and a case where the filter is formed in the passage unit 20. Thus, the filters can be further integrated, so as to surely obtain the effect that a

variation of passage resistance in the individual ink passage is restrained to realize an improved printing quality.

[0060]

5 Moreover, since the filters 53f are formed at the portion to be a substantial center of the ink reservoir 52a, the excimer laser machining, etc., can be performed more easily and processing time thereof can be shortened, as compared with the first embodiment.

10 [0061]

 Moreover, the construction in which the filter is disposed between the ink introduction port 51a and the ink reservoir 52a can provide wide variance in position, number, and shape, etc., of the filter. Accordingly, the filter
15 can be formed at a position different from the position of the filter 53f in the second embodiment, and the number, size, and shape, etc., of the filter may properly be changed. When the filter is made smaller in number and larger in size, for example, a reduction of passage
20 resistance in ink passages can further be restrained, and additionally, ink is prevented from inconveniently clogging at pores constituting the filter. Moreover, deficiencies in pores may frequently be caused in case of making a large number of small-diameter pores by etching, etc.. In the
25 present embodiment, however, this problem of deficiencies

in pores can be decreased by enlarging the size of the filter. Further, it is also possible to give the filter a size and shape advantageous in strength.

[0062]

5 In addition, the same effects as those of the first embodiment described above can be obtained due to the constructions where a filter is not formed in the flat plates 21 to 29 constituting the passage unit 20 (see FIG. 6), where the filters 53f are formed in the plate 53, which
10 is one of the plates constituting the branching passage unit 50, and where the third plate 53 formed with the filters 53f has a layered structure laminated with the metal plate 53a and the resin plate 53c.

[0063]

15 Next, an ink-jet head according to a third embodiment of the present invention will be described with reference to FIGS. 9 to 12. An ink-jet head 202 of the present embodiment differs from those of the first and second
20 embodiments only in its branching passage unit. The other components, such as a passage unit 20, etc., are identical to those of the first embodiment, and therefore, will not be described by designating them by common reference numerals.

[0064]

25 As illustrated in FIG. 9, a branching passage unit 60

includes a first plate 61, a second plate 62, and filter supporting members 63. The first plate 61 and the second plate 62 are made of metal such as stainless steel. The first plate 61 and the second plate 62, having almost the same shape, are laminated with each other, as illustrated in FIG. 10. On the other hand, the filter supporting members 63, which are included in a below-described filter assembly 73 (see FIG. 11), are arranged so as to cover respective inlet ports 20a on a surface of the passage unit 20, as illustrated in FIG. 12. The second plate 62 is disposed on the filter supporting members 63.

[0065]

The first plate 61 is, as shown in FIG. 10, identical to the first plate 41 in the first embodiment, and has an ink introduction port 61a at a widthwise center on one side of the plate in a longitudinal direction.

[0066]

A concavity to constitute an ink reservoir 62a and notches 62c are formed in the second plate 62 facing the first plate 61. The concavity to constitute the ink reservoir 62a and the notches 62c are similar to the concavity to constitute the ink reservoir 52a and notches 52c in the second embodiment (see FIG. 8), respectively. Further, similarly to the ink outlet ports 52b in the second embodiment, ink outlet ports 62b penetrating through

the plate in its thickness direction are formed at vicinities of the notches 62c.

[0067]

Protrusions 62h are formed at areas enclosed with alternate long and short dash lines in FIG. 10, facing the passage unit 20. Portions other than the protrusions 62h exist on the same plane. Similarly to the protrusions 42h and 52h in the first and second embodiments, the protrusion 62h has such a height that an FPC 4 may be drawn out from a space 44 to the outside. The protrusion 62h closes the space 44 in which an actuator unit 19 is to be arranged (see FIG. 9). The space 44 is formed at a portion where the filter supporting members 63 are not arranged when the second plate 62 is fixed to the passage unit 20 with the filter supporting members 63 sandwiched therebetween.

[0068]

The filter assembly 73 used for the ink-jet head 202 of the present embodiment will hereinafter be described with reference to FIG. 11.

[0069]

The filter assembly 73 comprises four filter supporting members 63 disposed to neighbor each other, interconnecting portions 73d for interconnecting the neighboring filter supporting members 63, a frame portion 73g surrounding peripheries of the four filter supporting

members 63, and peripheral connecting portions 73e for connecting the frame portion 73g and the filter supporting members 63 adjacent to the frame portion 73g.

[0070]

5 Each interconnecting portion 73d has an elongated shape elongated in a direction of connecting the filter supporting members 63 with each other. A bending strength of a boundary between each interconnecting portion 73d and each filter supporting member 63 is smaller than a bending
10 strength of the filter supporting members 63. A bending strength of a boundary between each peripheral connecting portion 73e and each filter supporting member 63 is also smaller than the bending strength of the filter supporting members 63.

15 [0071]

Filters 63f corresponding to the respective inlet ports 20a (see FIG. 12) are formed in each of the four filter supporting members 63. Among the four filter supporting members 63, two filter supporting members 63 as
20 disposed on this side in FIG. 11 are in generally rectangular shape, and each has two filters 63f corresponding to each pair of inlet ports 20a. Remaining two filter supporting members 63 are in generally L shape, and each has three filters 63f each corresponding to a pair
25 of inlet ports 20a and a single inlet port 20a disposed

opposite to that pair of inlet ports 20a.

[0072]

The filter supporting members 63 are formed in such a shape as to be arranged alternately without overlapping with the actuator units 19 (illustrated on the passage unit 20 with alternate long and two short dashes lines in FIG. 12) on a surface of the passage unit 20. In the filter assembly 73 shown in FIG. 11, the filter supporting members 63 are disposed to neighbor each other at a distance shorter than a distance at which they are to be arranged on the surface of the passage unit 20 (see FIG. 12).

[0073]

The filter supporting members 63, the interconnecting portions 73d, the frame portion 73g, and the peripheral connecting portions 73e are formed in one piece.

[0074]

The filter assembly 73 is, as shown in FIG. 11, formed by a metal plate 73a such as a plate of stainless steel and a resin plate 73c such as a plate of polyimide being laminated with each other. Each component of the filter assembly 73 is formed by etching the metal plate 73a to leave outlines of the filter supporting members 63 and the frame portion 73g, and subsequently applying laser machining to the resin plate 73c to leave outlines of the interconnecting portions 73d and the peripheral connecting

portions 73e in addition to outlines of the filter supporting members 63 and the frame portion 73g.

[0075]

Thus, the filter supporting member 63 has a layered structure laminated with a metal plate 63a and the resin plate 73c. Then, openings 63b as illustrated in FIG. 9 are formed by etching portions of the lower metal plate 63a corresponding to the filters 63f. Thereafter, the filters 63f are formed in the filter supporting members 63 by making, with excimer laser machining, a large number of small-diameter pores (16 to 24 micrometers) to neighbor each other concentratedly at portions of the upper resin plate 63c corresponding to the openings 63b.

[0076]

The number of processing steps can be reduced by performing two etchings at the same time, i.e., the etching in the metal plate 73a of the filter assembly 73, and the etching for forming the openings 63b in the metal plate 63a of the filter supporting members 63.

[0077]

The four filter supporting members 63 having the above construction are arranged on the surface of the passage unit 20 as illustrated in FIG. 12, and the second plate 62 and the first plate 61 are laminated on the filter supporting members 63, so that an ink branching passage for

branching ink from the ink introduction port 61a to the ink outlet ports 62b and then to the filters 63f formed in the filter supporting members 63 is formed within the branching passage unit 60.

5 [0078]

As described above, according to the filter assembly 73 of the present embodiment, the number of parts can be restrained, because the four filter supporting members 63 are manufactured as a single part. Accordingly, the filter
10 assembly 73 is compact and easy to handle while comprising four filter supporting members 63.

[0079]

Additionally, since the filter supporting members 63 are disposed to neighbor each other, processing time for
15 forming the filters 63f can be shortened, particularly in case of applying excimer laser machining. This is because a relatively short distance between the filters 63f can shorten a traveling distance of a laser head in performing excimer laser machining. Such a shortening of the
20 processing time can reduce manufacture costs.

[0080]

Moreover, the filter supporting members 63 are disposed to neighbor each other at a distance shorter than a distance at which they are to be arranged on the surface
25 of the passage unit 20, and the filters 63f are thereby

disposed collectively. Therefore, a processing efficiency, particularly as described above, can be improved. When each filter supporting member 63 is arranged on the surface of the passage unit 20, on the other hand, the filter
5 supporting members 63 may be arranged at a distance from each other so as to flexibly correspond to various layouts of the inlet ports 20a.

[0081]

Further, a compact layout of the actuator units 19
10 and the filter supporting members 63 can be realized, because each filter supporting member 63 is formed in such a shape as to be arranged alternately without overlapping with the actuator units 19 on the surface of the passage unit 20, as shown in FIG. 12. This can realize a
15 compactification of the head 20a.

[0082]

Still further, the filter supporting members 63 can easily be separated from each other, because the filter supporting members 63 are connected with each other by
20 means of the interconnecting portions 73d each having the elongated shape elongated in the direction of connecting the filter supporting members 63.

[0083]

Still further, the filter assembly 73 comprises the
25 frame portion 73g surrounding the peripheries of the four

filter supporting members 63, and therefore, can be handled more easily. For example, a problem that the filter supporting members 63 may be damaged during transportation of the filter assembly 73 can be decreased.

5 [0084]

Still further, since the filter supporting members 63, the interconnecting portions 73d, the frame portion 73g, and the peripheral connecting portions 73e are formed in one piece, manufacture costs can be reduced.

10 [0085]

Next, a method for manufacturing the ink-jet head 202 using the filter assembly 73 according to the present embodiment will be described. Here will be described, however, a method for manufacturing only the head main body 202a in the head 202 illustrated in FIG. 9.

15 [0086]

First, the passage unit 20 is formed by positioning and laminating the flat plates 20 to 29 (see FIG. 6), while manufacturing the filter assembly 73 illustrated in FIG. 11.

20 [0087]

In a manufacturing process of the filter assembly 73, the filter supporting members 63, the interconnecting portions 73d, the frame portion 73g, and the peripheral connecting portions 73e are formed in one piece, as described above. In this process, additionally, the four

filter supporting members 63 are disposed to neighbor each other at the distance shorter than the distance at which they are to be arranged on the surface of the passage unit 20 (see FIG. 12). Moreover, the filters 63f are formed by
5 excimer laser machining, as described above.

[0088]

The four filter supporting members 63 get separated from each other by bending the interconnecting portions 73 at the boundaries between the interconnecting portions 73
10 and the filter supporting members 63. The frame portion 73g and the filter supporting members 63 adjacent to the frame portion get separated from each other by bending the peripheral connecting portions 73e at the boundaries
between the peripheral connecting portions 73e and the
15 filter supporting members 63. In this separating process, a cutting may be performed, for example, by applying force to an appropriate interconnecting portion 73d or peripheral connecting portion 73e while holding the filter assembly 73 by hand.

20 [0089]

Then, as shown in FIG. 12, each filter supporting member 63 is arranged on the surface of the passage unit 20 such that each filter 63f may face each inlet port 20a.

[0090]

25 Subsequently, the actuator units 19 are alternately

arranged on the surface of the passage unit 20 so as not to overlap with the filter supporting members 63 arranged in the above-described manner. A process of arranging the actuator units 19 may be either before or after a process of arranging the filter supporting members 63, and these two processes may also be coincident.

[0091]

The first and second plates 61 and 62 bonded to each other and constituting the branching passage unit 40 are fixed to the passage unit 20 such that each filter supporting member 63 may contact with an appropriate position in the lower face of the second plate 62.

[0092]

In the head main body 202a having the above construction, as illustrated in FIG. 5A for example, ink introduced from the ink supply source 200 is firstly introduced from the ink introduction port 61a into the ink reservoir 62a, where the ink is reserved for a time. Then, the ink in the ink reservoir 62a is led, through the notches 62c, from the ink outlet ports 62b, and further the ink passes through the filters 63f formed in the filter supporting members 63. At this time, foreign matters mixed in the ink is removed by the filters 63f. The ink having passed through the filters 63f is led, through the openings 63b, to the inlet ports 20a in the passage unit 20, and

then introduced into the manifold channel 30. The ink flows from the manifold channel 30 to the ink ejection port 13 in the same manner as in the first embodiment. Thus, the description of the ink flow thereafter is omitted.

5 [0093]

As described above, the same effects as those of the above-described filter assembly 73 can be obtained by the method for manufacturing the ink-jet head 202 using the filter assembly 73. Moreover, the ink-jet head 202 having
10 the same effect as that of the ink-jet head 2 in the first embodiment, i.e., the effect that a variation of passage resistance in the individual ink passage is restrained to realize an improved printing quality, can be manufactured using the filter assembly 73.

15 [0094]

In the aforementioned first, second, and third embodiments, the pores constituting the filter, 43f, 53f, and 63f may be formed by various methods, not limited to the excimer laser machining.

20 [0095]

The resin plates 43c, 53c, 63c, and 73c may be made of various resins such as polyester or vinyl chloride, etc., instead of polyimide. The metal plates 43a, 53a, 63a, 73a, the first plates 41, 51, 61, and the second plates 42, 52,
25 62 may be made of various metals, for example, nickel alloy

such as 42ALLOY or INVAR, etc., instead of stainless steel.

[0096]

The members formed with the filters 43f, 53f, and 63f are not limited to the layered structure laminated with the metal plate and the resin plate, and may be a plate made of
5 a single material.

[0097]

The number of ink introduction ports 41a, 51a, and 61a is not limited to one, and the number of the ink
10 introduction ports formed may be optional. The shape of the ink introduction ports may also be variously changed.

[0098]

The shape of the ink outlet ports 43b, 52b, 62b may also be variously changed, and may be, for example, square
15 shape or elliptic shape. The filters 43f and 63f in the first and third embodiments are formed in the same shape as that of the ink outlet ports 43b and 62b.

[0099]

The reservoir communication hole 53b in the second
20 embodiment may formed in optional numbers, in optional shapes, and at optional positions, as long as the reservoir communication hole 53b is capable of introducing ink into the ink reservoir 52a. In this case, the number, shape and position of the filters 53f need to be conformed with those
25 of the reservoir communication holes 53b.

[0100]

In the first and second embodiments, the branching passage unit is not necessarily formed by laminating a plurality of plates, as long as a filter is formed in an ink branching passage within the branching passage unit.

[0101]

In the third embodiment, the filter supporting member 63 may be designed so as to cover any optional inlet port 20a.

10 [0102]

In the third embodiment, moreover, a press working may be performed for manufacturing the filter assembly 73 so as to leave the filter supporting members 63, the interconnecting portions 73d, the peripheral connecting portions 73e, and the frame portion 73g, all of which are components.

[0103]

In the third embodiment, moreover, it is satisfactory to form the interconnecting portions 73d and the peripheral connecting portions 73e to have such a strength as to avoid damaging during transportation of the filter assembly 73. Accordingly, both of the interconnecting portions 73d and the peripheral connecting portions 73e may be formed in either of the resin plate 73c and the metal plate 73a, and their number and position, etc., are not particularly

limited.

[0104]

In the third embodiment, moreover, the filter supporting members 63, the interconnecting portions 73d, the frame portion 73g, and the peripheral connecting portions 73e may not be formed in one piece.

[0105]

In the third embodiment, moreover, the number of the filter supporting members 63 included in the filter assembly 73 is not limited as long as no less than two filter supporting members 63 are included.

[0106]

The present invention can be applied to, for example, a serial type of ink-jet printer, which performs a printing by transferring a paper as well as reciprocating the head main body 2a perpendicularly to the transferring direction of the paper, instead of the line type of the ink-jet printer as in the aforementioned embodiments, which performs a printing by transferring a paper with respect to the fixed head main body 2a.

[0107]

Further, the application of the present invention is not limited to an ink-jet printer. The present invention is also applicable, for example, to an ink-jet type facsimile or copying machine.

[0108]

While this invention has been described in
conjunction with the specific embodiments outlined above,
it is evident that many alternatives, modifications and
5 variations will be apparent to those skilled in the art.
Accordingly, the preferred embodiments of the invention as
set forth above are intended to be illustrative, not
limiting. Various changes may be made without departing
from the spirit and scope of the invention as defined in
10 the following claims.